

Date: Wednesday, 7/12/2006 3:23:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW KIT (19"X24")
 Job Number : 27871
 Estimate Number : 10323
 P.O. Number : N/A Part Number : K10008
 This Issue : 7/12/2006 S.O. No. : N/A Drawing Number : D2432 REV F3
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F3
 Previous Run : 27357 Material : N/A
 Due Date : 7/30/2006 Qty: 10 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.07.12*
 Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D427-659-011

D315-670-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

(10)
KJ 06.07.17

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: *M101627*

J.F. 06/07/23

16

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.F. 06/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F/9/24 06/07/24

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/25 X 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050

Rubber Cushion

B24870 58 20434x2

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

2 D2432F(ref only)

Bearpaw

B26500 x 50 B27581x70 27871

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438

Clamp

B27080 ✓

5 ST/16

W/O:		WORK ORDER CHANGES						
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Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B26485 ✓

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B26472 ✓

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19185 ✓

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M19471 ✓

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M101369 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/08/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Part Number: K10008

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

15.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M19085

26/07/06

06/07/26

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/07/26

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: new E

06/07/26 (4)

06/08/14 (6)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/15 (18)

Job Completion



06/08/15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27871
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.058 x 45°	—		
B	5.500	+/-0.030	5.500	✓		
C	0.200	+/-0.030	0.200	✓		
D	0.25 x 45°	+/-0.030	0.250 x 45°	—		
E	R0.250	+/-0.030	R0.250	✓		
F	0.250	+/-0.010	0.243	✓		
G	0.625	+/-0.030	0.610	✓		
H	0.375	+/-0.010	0.382	—		
I	0.950	+0.030/0.010	0.954	—		
J	19.000	+/-0.030	19.000	—		
K	3.14	+/-0.030	3.128	—		
L	3.28	+/-0.030	3.310	✓		
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		
N	Ø0.93	+/-0.030	Ø0.927	—		
O	0.30	+0.030/-0.000	0.305	✓		
P	23.750	+/-0.030	23.750	✓		
Q	7.375	+/-0.030	7.375	—		
R	4.250	+/-0.010	4.250	✓		
S	2.000	+/-0.030	2.000	—		
T	9.000	+/-0.010	9.000	✓		
U	9.000	+/-0.010	9.000	✓		
V	0.375	+/-0.010	0.382	✓		

Measured by: <i>ml</i>	Audited by: <i>En</i>	Prototype Approval:	N/A
Date: 06/07/24	Date: 06/07/24	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>AF</i>

DARTDART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADAREV. F
SHEET 1 OF 2

SCALE

DESIGN	DRAWN BY	DRAWING NO.	TITLE
KE	KE	D2432	BEARPAW
CHECKED MM	APPROVED JS		
DATE 98.05.12			

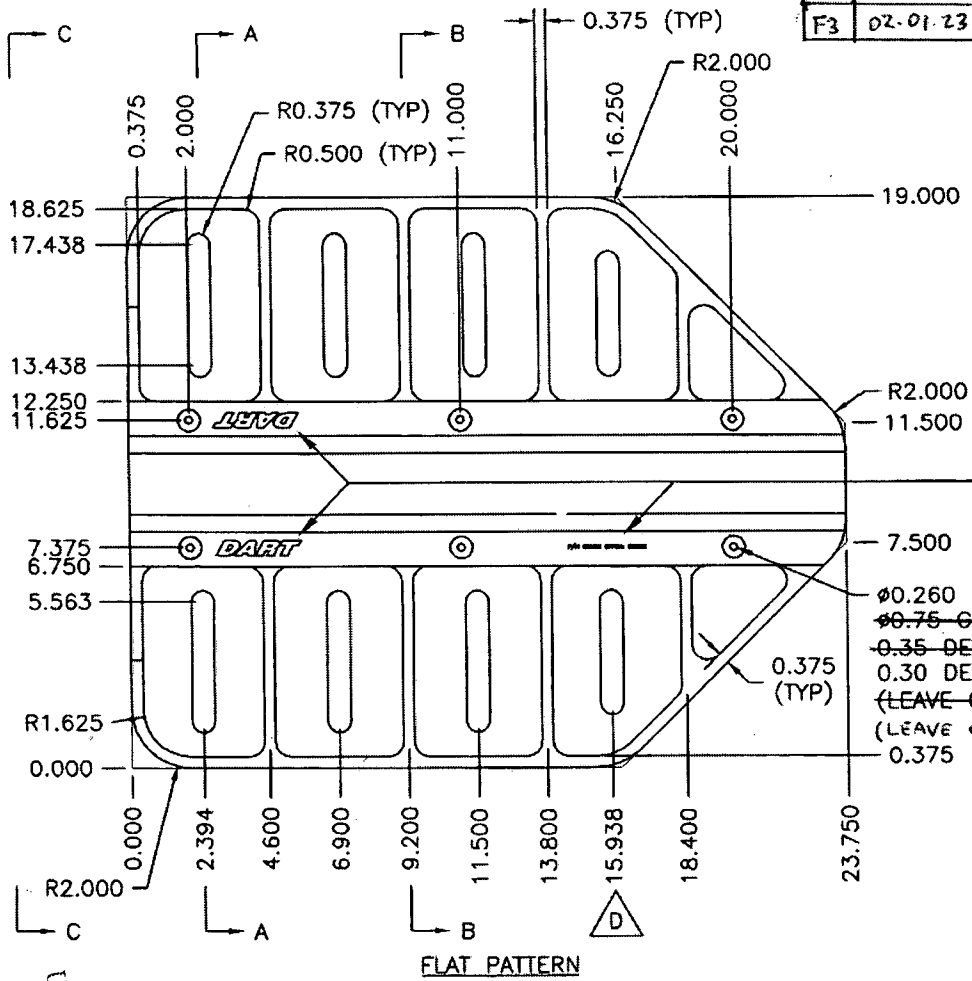
RELEASED
98.06.17 KE

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

△ F2
△ F1
△ F
△ F1

EFFECTIVE DEOS
9143

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375

BEND AFTER MACHINING
(D2432B ONLY)

0.950 (REF)

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

△ F

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

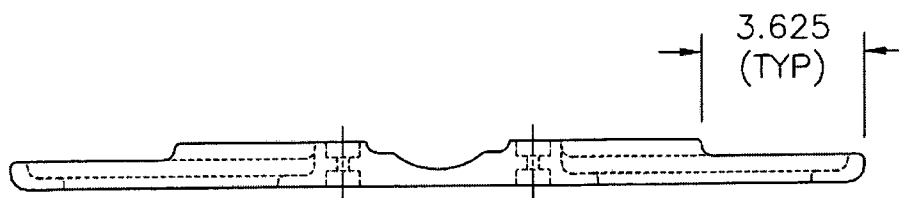
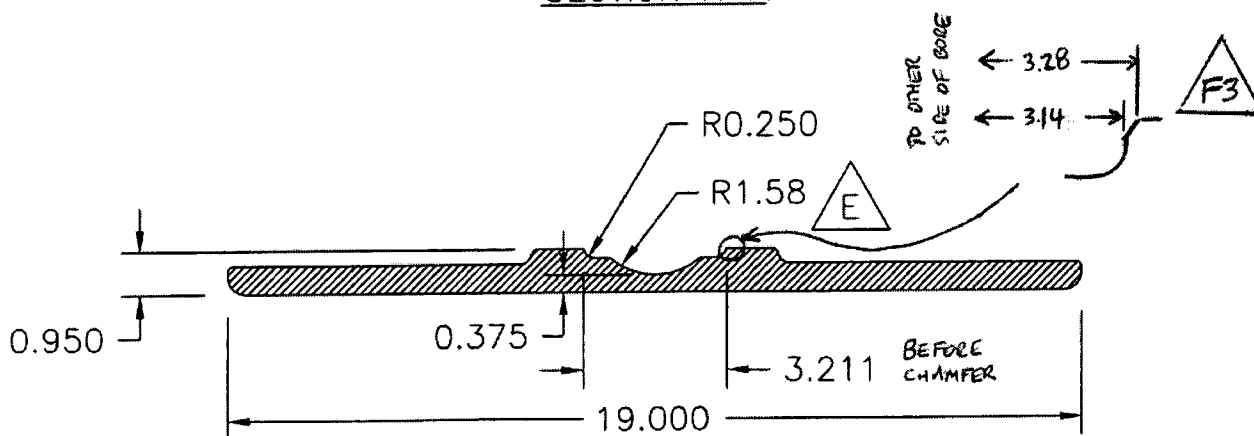
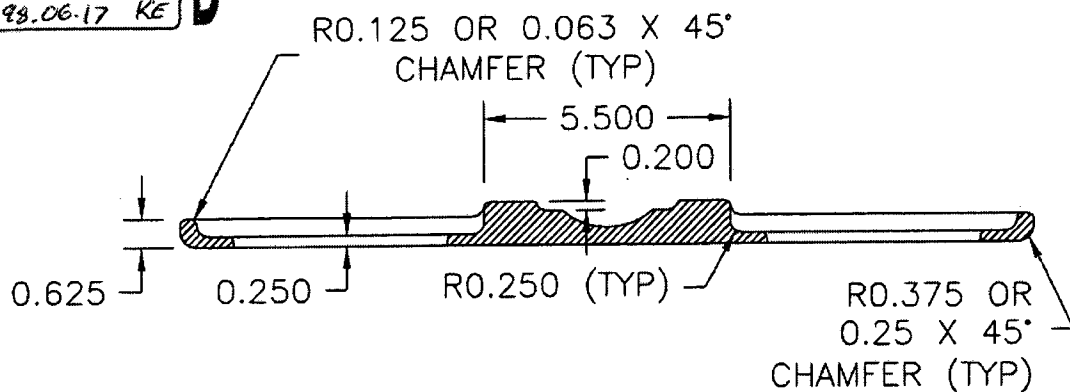
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MA	APPROVED CA	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

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98.06.17 KE



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